

Work Order ID 58821

May 19, 2010 9:10:36 AM



Page 1

Item ID: D206-628-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 5/19/10 Start Qty: 5.00



Cust Item ID:

Required Date: 5/21/10 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9500	A
IIN-D206-628	Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy blue file and type labels as per P

Handwritten: Hg for BG 10/06/10 (5)

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D206-628-013	CHG	CHG004	STC	SH98-14
DESC.	Heli-Access-Step LH	STC	SA00500SE		
LOT	B52159	STC			
MODEL	Bell 206A/B	STC			
MADE IN CANADA D2729-1					

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D206-628-013	CHG	CHG004	STC	SH98-14
DESC.	Heli-Access-Step LH	STC	SA00500SE		
LOT	B52159	STC			
MODEL	Bell 206A/B	STC			
MADE IN CANADA D2729-1					

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D206-628-013	CHG	CHG004	STC	SH98-14
DESC.	Heli-Access-Step LH	STC	SA00500SE		
LOT	B52159	STC			
MODEL	Bell 206A/B	STC			
MADE IN CANADA D2729-1					

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D206-628-013	CHG	CHG004	STC	SH98-14
DESC.	Heli-Access-Step LH	STC	SA00500SE		
LOT	B36963	STC			
MODEL	Bell 206A/B	STC			
MADE IN CANADA D2729-1					

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	206-628-013	CHG	CHG004	STC	SH98-14
DESC.	Heli-Access-Step LH	STC	SA00500SE		
LOT	B52159	STC			
MODEL	Bell 206A/B	STC			
MADE IN CANADA D2729-1					

Work Order ID 58821

May 19, 2010 9:10:36 AM



Page 2

Item ID: D206-628-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 5/19/10 Start Qty: 5.00



Cust Item ID:

Required Date: 5/21/10 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

1 X D206-628-013 B36963

4 X D206-628-013 B52159

CHANGE AS FOLLOWS PER ECN10-530:

REMOVE FROM KITS:

2 X D2731-3 B

2 X D3394-041 B

16 X AN960C416L B

ADD:

2 X D2731-7 B

2 X D3394-043 B

1 X D4064-041 B

16 X AN960C416 B

5+

10-5-21 SL

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5060610

25

Work Order ID 58821



Page 3

May 19, 2010 9:10:37 AM

Item ID: D206-628-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 5/19/10 Start Qty: 5.00



Cust Item ID:

Required Date: 5/21/10 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	REPACKAGE PER PPP USING NEW B/N # CHG 006								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/06/14

10/06/14

MF
10-6-14

Picklist Print

May 19, 2010 9:10:33 AM

Page 1

Work Order ID: 58821

Parent Item: D206-628-013

Parent Item Name: Heli-Access-Step LH

Start Date: 5/19/10

Required Date: 5/21/10

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD IPP Rev:G
 per DSI9500 DD 10.03.01 verified by:JLM

Start Qty: 5.00

Required Qty: 5.00

AN960C416

Purchased

No

Each

346.0000

16



washer

Location

Loc Qty

Loc Code

ST346

346

100993

346

Each

908.0000

AN960C416L



WASHER

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

864

112612

25

112794

439

112828

400

Each

118.0000

D2731-3



Mounting Lug

Location

Loc Qty

Loc Code

ST469

118

47967

79

52329

39

16-5-21 5/10

4 80

m 69220 24 14
 m 712612 24 24

9442 46

13 37335 200 6/16/10

Picklist Print

May 19, 2010 9:10:34 AM

Page 2

Work Order ID: 58821



Parent Item: D206-628-013



Parent Item Name: Heli-Access-Step LH

Start Date: 5/19/10

Required Date: 5/21/10

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD IPP Rev:G
 per DSI9500 DD 10.03.01 verified by:JLM

Start Qty: 5.00

Required Qty: 5.00

D2731-7 Manufactured No 110 Each 71.0000 4



Mounting Lug



10-5-218

Location	Loc Qty	Loc Code
ST470	71	
41597	23	
<u>52330</u>	40	
55773	8	

5
5

D3394-041 Manufactured No



Lug Assembly

Each 44.0000



B37375 2p
B37970 8p

Location	Loc Qty	Loc Code
ST474	44	
53446	4	
56528	40	

D3394-043 Manufactured No



Lug Assembly

110 Each 111.0000 4



10-5-218 (5x)

Location	Loc Qty	Loc Code
ST475	111	
44521	5	
<u>45365</u>	50	
52331	45	
55772	11	

10

Picklist Print

May 19, 2010 9:10:34 AM

Page 3

Work Order ID: 58821



Parent Item: D206-628-013



Parent Item Name: Heli-Access-Step LH

Start Date: 5/19/10

Required Date: 5/21/10

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:
IPP rev F ncr 09-004 09.01.09 EC verified by:DD IPP Rev:G
per DSI9500 DD 10.03.01 verified by:JLM

Start Qty: 5.00

Required Qty: 5.00

D4064-041

Manufactured No

110

Each

13.0000

1



Mounting Lug



Location

Loc Qty

Loc Code

ST464

13

56549

3

56671

10

10-5-2151 (51)
B58980 14 10/6/10
44 56671

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE

REF TCCA STC: SH98-14

REF EASA STC EASA.IM.R.S.01339

PURPOSE:

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

CHANGE:

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY -013	QTY -014	QTY -023	QTY -024	QTY -033	QTY -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INSTALLATION, LH
	X					D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2					D2731-3	MOUNTING LUG <i>Remove</i>
2	2					D2731-7	MOUNTING LUG <i>leave</i>
2	2					D3394-041	MOUNTING LUG <i>Remove</i>
2	2					D3394-043	MOUNTING LUG <i>leave</i>
16	16					AN960C416L	WASHER <i>Remove</i>

IS:

4	4					D2731-7	MOUNTING LUG <i>add 2</i>
4	4					D3394-043	MOUNTING LUG <i>add 2</i>
1	1					D4064-041	MOUNTING LUG (NEW) <i>add</i>
1	1					*D4064-1	LUG
2	2					*MS35489-93	GROMMET <i>add</i>
16	16					AN960C416	WASHER <i>add</i>

* DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

58821

A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>QP</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>QP</i>		
CHECKED	<i>3</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9500	SHEET 1 OF 4
APPROVED	<i>H</i>	TITLE	SCALE
DE APPR.	<i>H</i>	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE

REF TCCA STC: SH98-14

REF EASA STC EASA.IM.R.S.01339

PURPOSE:

UNMODIFIED DART A/E FLOAT STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

CHANGE:

D206-628-013/014 INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

CONTRARY TO PREVIOUS INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/014 INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF **17.25"** PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING NEW MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN4C WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 1 (FIG. 12) OF IIN-D206-628-013/014 REV. F IS AMENDED AS FOLLOWS:

QTY	QTY	QTY	QTY	QTY	Part Number	Description
-013	-014	-013	-014	-013		
X					D206-628-013	206 A/E FLOAT STEP INSTALLATION, LH
	X				D206-628-014	206 A/E FLOAT STEP INSTALLATION, RH

WAS:

2	2				D2731-3	MOUNTING LUG
2	2				D2731-7	MOUNTING LUG
2	2				D3334-041	MOUNTING LUG
2	2				D3334-043	MOUNTING LUG
16	16				AN960C416L	WASHER

IS:

4	4				D2731-7	MOUNTING LUG
4	4				D3334-043	MOUNTING LUG
					D4034-041	MOUNTING LUG (NEW)
1	1				D4064-1	LUG
2	2				WAS35489-93	GROMMET
16	16				AN960C416	WASHER

* DENOTES ITEMS INCLUDED IN ASSEMBLY ABOVE

A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	10.01.29		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
DSI 9500	SHEET 1 OF 4
TITLE	SCALE
MOUNTING LUG CHANGE	NTS

COPYRIGHT © 2019 DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND NOT TO BE RELEASED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries